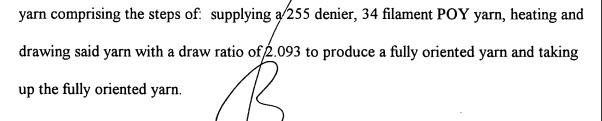
## WHAT IS CLAIMED IS:

- A process to provide fully oriented industrial yarn from low molecular weight polyester partially oriented yarn comprising the steps of: providing a bobbin of polyester POY multifilament synthetic yarn, supplying said yarn to a heater, drawing said yarn in a draw zone with a draw ratio in the range of 1.8 2.3 as it passes over the heater to produce a fully oriented yarn and taking up the fully oriented yarn.
- 2. The process of Claim 1 wherein said yarn so overfed about 1% to said draw zone.
- 3. The process of Claim 2 wherein said heater is operating at about a temperature of 210°C.
- 4. The process of Claim 3 wherein said yarn is pretensioned prior to the supply of same to the draw zone.
- 5. The process of Claim 2 wherein said drawn yarn is supplied to a second draw zone wherein it is relaxed.
- 6. The process of Claim 5 wherein heat from a heater operating at about 210°C relaxes said drawn yarn.
- 7. The process of fully orienting a 255/denier, 34 filament low molecular weight polyester

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8. The process of Claim 7 wherein-the heater for said yarn is operated at a temperature of about 210°C.

## **APPENDIX**

- 11. A process to provide a fully oriented single ply industrial yarn from a single ply low molecular weight polyester partially oriented yarn comprising the steps of: providing a bobbin of single ply polyester POY multifilament yarn, the single ply yarn to a heater, drawing said single ply in a draw zone in the range of 1.8 2.3 as it passes over the heater to produce a fully oriented, single ply yarn and supplying the fully oriented single ply yarn directly to a take-up roll without further processing.
- 12. The process of Claim 11 wherein said yarn is pretensioned prior to the supply of same to the draw zone.
- 13. The process of Claim 12 wherein said heater is operating at about a temperature of 210°C.
- 14. The method of Claim 13 wherein the yarn is pretensioned with a draw ratio of 1.01.
- 15. The process of Claim 11 wherein said drawn yarn is supplied to a second draw zone wherein it is relaxed.
- 16. The process of Claim 15 wherein heat from a heater operating at about 210°C relaxes said drawn yarn.
- 17. The process of fully orienting a 255 denier, 34 filament low molecular weight polyester yarn comprising the steps of: supplying a 255 denier, 34 filament POY yarn, heating and drawing said yarn with a draw ratio of 2.093 to produce a fully oriented yarn and taking up the fully oriented yarn.

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18. The process of Claim 17 wherein the heater for said yarn is operated at a temperature of about 210°C.